

Work Order ID 141115

141115

Page 1

January 27, 2016 8:48:33 AM

Item ID: D3370-051 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Lock Assembly

Start Date: 1/27/2016 Start Qty: 2.00 ***S*** **1** **GA** Cust Item ID:
 Required Date: 2/5/2016 Req'd Qty: 2.00 ***S*** Customer:

Reference:

Approvals: Process Plan: **GA** Date: **20160126** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3370	Rev C								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.02							
Small Fab	ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT Assemble as per dwg D3370								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: G.A.	0.00							
120									
Packaging	Memo	0.00							
Packaging									

1 **FF** **JAN 28 2016**
D **FF** **JAN 28 2016**
DAS
38
9-89
JAN 28 2016
1 **FF** **JAN 28 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
			OTHER : ☐					

Work Order ID 141115***141115***

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Item ID: D3370-051 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pedal Lock Assembly
Start Date: 1/27/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 2/5/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MC5 JAN 29 2016

MC5 JAN 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 141115

141115

Parent Item: D3370-051

D3370-051

Parent Item Name: Pedal Lock Assembly

Start Date: 1/27/2016

Required Date: 2/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP a07.11.29new issue EC
IPP Rev:B 08-07-17 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D338-028		Purchased	No			100	Each	76.0000	2	4			
238-028									**				DAS 26 9-89
3/16" Dowel Pin .5" long													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				9					
				M103114				9					
				ST568				67					
				M132062				67		21			
AN526C832R6		Purchased	No			100	Each	36.0000	4	8			DAS 30 9-89
AN526C832R6									**				DAS 26 9-89
Screw													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				36					
				m131379				36		4			
D3370-1		Manufactured	No			100	Each	1.0000	1	2			DAS 26 9-89
D3370-1									**				
Pedal Lock Base													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST497				1					
				123359				1		1			
D3370-3		Manufactured	No			100	Each	0.0000	1	2			DAS 26 9-89
D3370-3									**				
Pedal Lock Cover													
										1x		BK0709	

JAN 28 2016

Picklist Print

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Work Order ID: 141115

141115

Parent Item: D3370-051

D3370-051

Parent Item Name: Pedal Lock Assembly

Start Date: 1/27/2016

Required Date: 2/5/2016

Start Qty: 2.00

Required Qty: 2.00

D3373-5

Manufactured No

100

Each

89.0000

1

2

D3373-5

Cam Lock

DAS
30
9-89

~~DAS
26
9-89~~

Location

Loc Qty

Loc Code

GA

46

22244

42

96256

4

ST032

37

22383

37

ST036

6

22477

6

D3385-3

Manufactured No

100

Each

21.0000

1

2

D3385-3

Hinge

DAS
26
9-89

Location

Loc Qty

Loc Code

ST034

21

117534

21

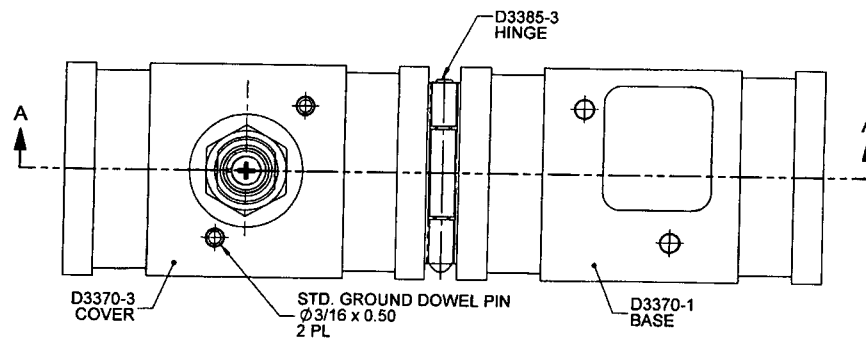
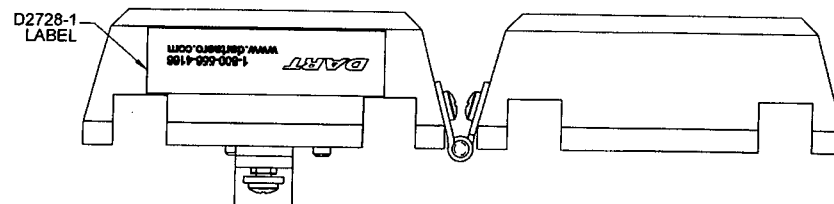
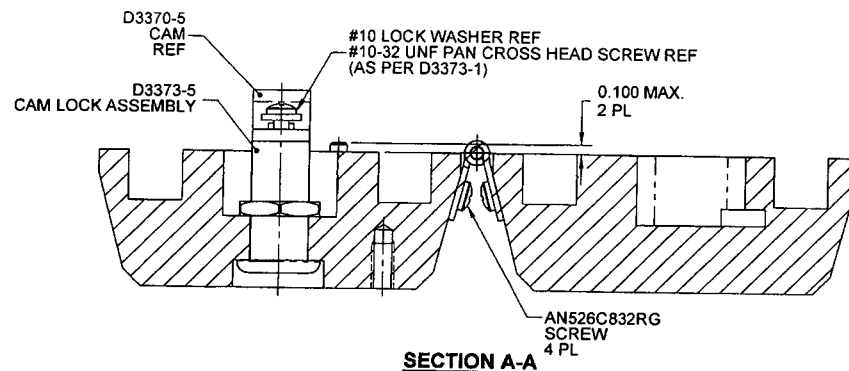
JAN 28 2016

/X

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
1		D2728-7	LABEL
1		D3370-1	BASE
1		D3370-3	COVER
1		D3373-5	CAM LOCK ASSY
1		D3385-3	HINGE
2		Ø3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
4		AN526C832R6	SCREW

120160126
 RELEASED
 08-07-16
 SH 141115

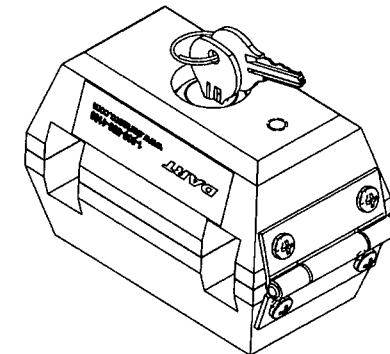
C	SHEET 1 ADDED P/L ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.		AJS	08.07.11
B	D3385-3 WAS D3385-1		MB	05.03.22
A	NEW ISSUE		RF	04.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3370	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		PEDAL LOCK	NTS	
DATE	08.07.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		



D3370-051 PEDAL LOCK ASSEMBLY

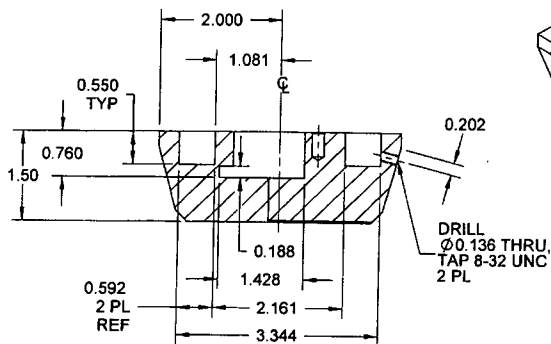
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

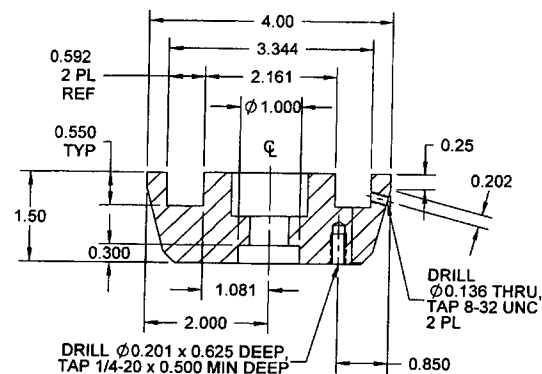
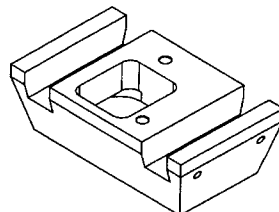


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08-07-11

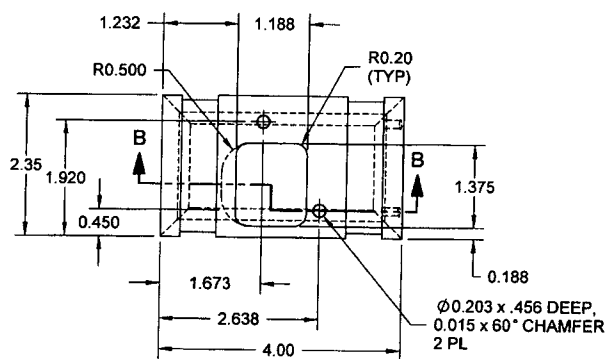
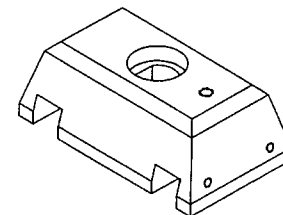
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DRAWN	AJS		
CHECKED	E	DRAWING NO. D3370	REV. C SHEET 2 OF 4
MFG. APPR.	E	TITLE PEDAL LOCK	SCALE NTS
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DE APPR.			
DATE	08.07.11		



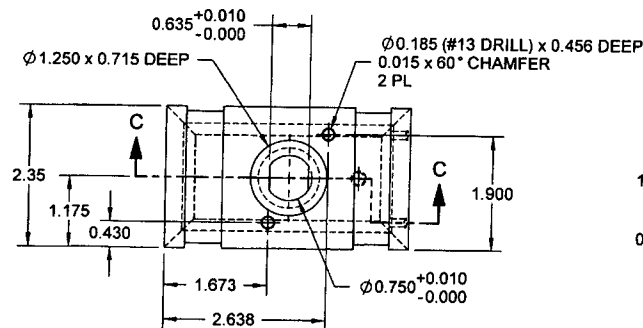
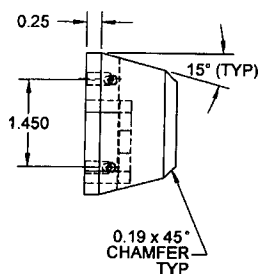
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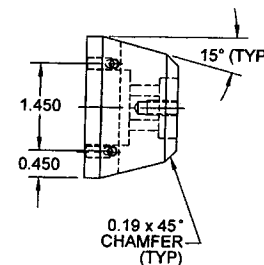
SECTION C-C



D3370-1 BASE



D3370-3 COVER

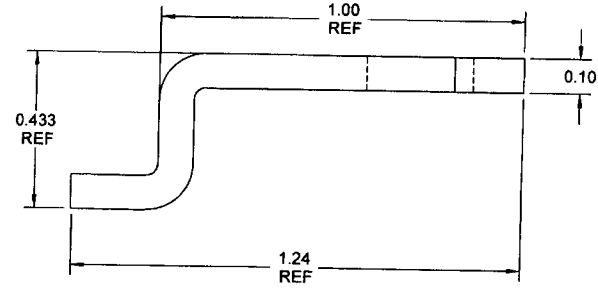
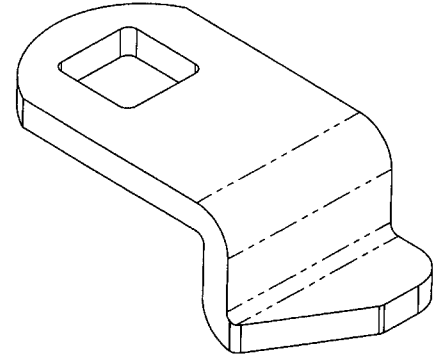
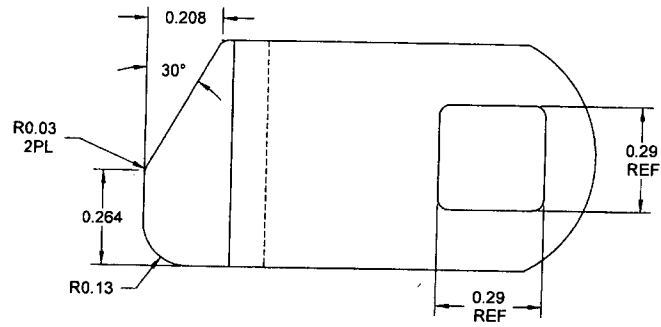


NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
08-07-16

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3370	REV. C SHEET 3 OF 4
MFG. APPR.		TITLE PEDAL LOCK	SCALE NTS
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DE APPR.			
DATE	08.07.11		



D3370-5 CAM

RELEASED
 08.07.11

- NOTES:**
 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	FE	DRAWING NO.	REV. C
MFG. APPR.	MB	D3370	SHEET 4 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	PEDAL LOCK	NTS
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